

5/15

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22546
<b>Description:</b> Wheel Shaft	<b>Part Number:</b>	D3334-1
<b>Dwg:</b> D3334 Rev. A	<b>Qty:</b>	8
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JH	05.02.24	8
2	MS	Cut blanks: Ø3.500" Bar to 7.500" long Material: 7075-T651 (QQ-A-200/11 or QQ-A-225/9) Bar (M7075T651R3.500) <b>Identify for D3334-1</b> Batch: _____			
3	MS	Turn as per Folio FA492 and Dwg D3334			
4	QC2	Inspect parts as they come off the CNC machine			
5	MS	Deburr			
6	MV	Machine as per Folio FA492 and Dwg D3334 <b>Identify as D3334-1</b>			
7	QC2	Inspect parts as they come off the CNC machine			
8	QC8	Second check			
9	QC5	Inspect work to step 8			
10	FP	Chemical Conversion Coat as per QSI 005 4.1			
11	QC3	Inspect Chemical Conversion Coat			
12	ST	Identify and Stock			
13	AC	Cost / part: <u>0</u>			
14	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED  
05.01.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

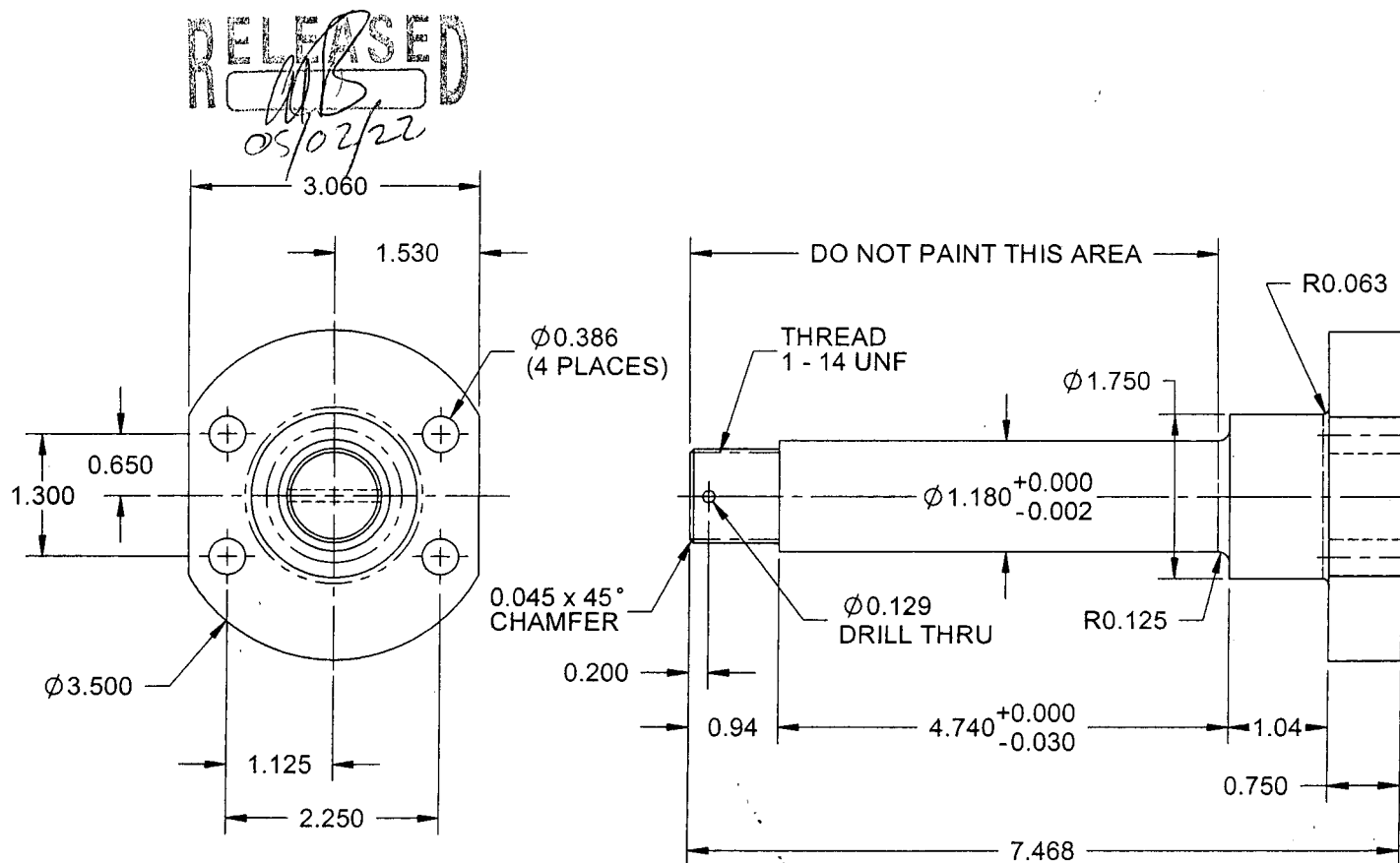
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3334	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE WHEEL SHAFT	SCALE 1:2
A	04.12.16	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	



### D3334-1 WHEEL SHAFT

#### NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03-GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 (REF. DART SPEC. M4140H-R3.500)
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY

TO  
ENGINEERING

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FOR AMENDMENT  
NOTICE

WORK ORDER

NO. 22546

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 23, 2005  
02:12 pm

Work Order No : 0022546  
Project Name : D3334-1  
Project For : WK515  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3334-1  
Description : Wheel Shaft  
Manufactured : Yes  
Amount Req'd : 8  
Amount Done : 0  
Start Date : 02-23-05  
Est Finish Date : 03-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00